

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 99.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-020890**Date Inspected:** 08-Dec-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 1500**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 300**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:****CWI Present:****Yes No****Inspected CWI report:** **Yes No N/A****Rod Oven in Use:** **Yes No N/A****Electrode to specification:** **Yes No N/A****Weld Procedures Followed:** **Yes No N/A****Qualified Welders:** **Yes No N/A****Verified Joint Fit-up:** **Yes No N/A****Approved Drawings:** **Yes No N/A****Approved WPS:** **Yes No N/A****Delayed / Cancelled:** **Yes No N/A****Bridge No:** 34-0006**Component:** OBG, Steel Barrier**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Dennis Combs, was present during the times noted above for the observations relative to the work being performed.

Trial Assembly

This Caltrans QA inspector received ZPMC non-destructive test (NDT) notification number 07690 from ZPMC for Trial Assembly. This QA inspector performed magnetic particle testing (MT) verification of welds after ZPMC had performed their MT inspection. The segment is identified as OBG CB16. The weld designations reviewed are as follows.

SSD27-PP105-069~084, 145~156

Bay 28

This Caltrans QA inspector received ZPMC non-destructive test (NDT) notification number 07691 from ZPMC for Bay 28. This QA inspector performed ultrasonic testing (UT) verification of welds after ZPMC had performed their UT inspection. The members are identified as OBG Sub Assemblies, and Steel Barriers. The weld designations reviewed are as follows.

SA3061A-009~038-001

SA3054C-001~015-005, 006

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

SA3053D-001~007-007, 008

E5-SB18-002-081

E5-SB13-048-050

E5-SB19-001-050

E5-SB13-101-081

E5-SB13-083-081

E5-SB19-002-050

E5-SB13-070-019

Description of Incident: During random in-process visual inspection of welds located on Steel Barriers at bay 28, this Quality Assurance Inspector (QA) observed that ZPMC personnel have removed 2 CJP, and 8 fillet weld joints to correct misalignment. This QA inspector was unable to locate ZPMC QC. Informed AB/FJV QC Bao Qian that welds were removed without engineering approval. The Steel Barrier number is identified as E5-SB13-066. A TL-015 Incident Report will be documented for the accordance.
See Photos Z:\Inspector Reports\B313 Combs\TL-6031.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

Conversation with AB/FJV QC Bao Qian regarding the above referenced incident at 23:53.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 150-0042-2372, who represents the Office of Structural Materials for your project.

Inspected By:	Combs,Dennis	Quality Assurance Inspector
----------------------	--------------	-----------------------------

Reviewed By:	Riley,Ken	QA Reviewer
---------------------	-----------	-------------